



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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647.2511

Job Sheet 188964



Part No: 647.2511

Job Qty: 12 pcs

Part Name: Nut

22 pcs



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/17/19

Job Tracking No:

Due Date: 2/1/19

Created By: Marie Lajeunesse

Type: Stock *SOLD*

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 12-10-22 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	12 pcs	2/1/19	2/1/19	0.00	5.72	Doosan - 1		<i>[Signature]</i>
110	QC 2	12 pcs	2/1/19	2/1/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		<i>[Signature]</i>
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		

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Container No: S146068



Part: 647.2511

Job No: 188964

Serial No/Batch: S146068

Revision:

Inspector:

Exp Date:

Instructions:

Date: 01/20/19

140	QC 8	12 pcs	2/1/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 38	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
150	Outsource - 17 - Passivate	12 pcs	2/1/19		GRO002-VC	7
160	Packaging 2-1 - Receive - B4B	12 pcs	2/1/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
170	QC 5	12 pcs	2/1/19	0.00 0.00	QC 5 - 10	

					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 38	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
180	Packaging 3-1 - Stock - B4B	12 pcs	2/1/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
190	QC 21 - SA	12 pcs	2/1/19	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
Part Op 100 - (Doosan Lathe) 1- Turn as per Folio FB144 AND DWG DWG Rev: _____ FOLIO Rev: _____ -Deburr per dwg Descriptions: ***CHECK THREADS USING GO/ NO GO GAUGE***** 110 - (QC2- Inspect parts off machine FAI/FAIB) 140 - (QC8- Inspect parts - second check) 100% CHECK,CHECK ALL DIMENSIONS AND THREAD FIT 150 - Issue P/O: _____ Pasivate as per MIL-S-5002 TYPE 6 Certificate of conformaty is required						

- 160 - (Receive & Inspect for Damage & Mat'l Certs) Ensure certificate of conformity is attached
 170 - (QC5- Inspect part completeness to step on W/O)
 180 - (Identify as per dwg & Stock Location: _____)
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H1150-R1.000	17-4 SS Round Bar 1.000"	.6000 ft (.05 ea)	100-Doosan - 1	412689

.065 ea

3978

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M17-4-H1150-R1.000	1	5	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Nut	0.875Inches ± 0.010	0.885 0.865	.879	
2	Nut	0.530Inches ± 0.010	0.540 0.520	.53	
3	Nut	90.000Degrees ± 0.500	90.500 89.500	90° Angle	✓
4	Nut	0.660Inches ± 0.010	0.670 0.650	.658	
5	Nut	0.130Inches ± 0.010	0.140 0.120	.131	
6	Nut	0.580Inches ± 0.002	0.582 0.578	.579	
7	Nut	0.590Inches ± 0.010	0.600 0.580	.5925	

Plex 1/17/19 8:41 AM Dart.lajeunesse.marie

M11 x 0.75 6H AC



DART
AEROSPACE

Route update only

Job: 188964

Part No. 647.2511

Rework	
Scrap	X
Use-as-is	

Skid-tube	
Machining	X
Large Fab	

Cross tube	
Small Fab	
Finishing	

Eng. (Non-AW)	
Prod. Eng. Coord.	
Rec/Store/Packaging	

Engineering	
Water Jet	
Supplier	
Quality	

Date : 01-22-19

Sequence #: 140-QCB

QTY Affected : 22

MRB (QSI042)
DAS
9
9-89 JAN 22 2019

Description Work Order Deviation

- PARTS TAPPED TO MILK 0.75 INSTEAD OF THE REQUIRED MILK 1.0

**DAS
68
9-89**

Disposition

- SCRAP ALL PARTS

DAS
68
9-89

Completed By

JAN 27 2019
Lead hand / Supervisor

Lead hand / Supervisor

QC / QA Coordinator
DAS
68
9-89
JAN 27 2019

Root Cause

Operator	X
Manufacturing Process	
Equip/Tooling	
Handling/Presservation	
Material	
Product Improvement	
Process Improvement	
Human Factors	X

☐	Pressure/Forced
☐	Bending
☐	Crushing
☐	Cracks
☐	Crimp/Kink/Ripple/Wave/Twist
☐	Marks/Chatter
☐	Mislabeled

Other/Details:

FAULT CATEGORY

☐	Contamination
☐	Misaligned/off center
☐	BOM/Route
☐	Broken/Damage/Defect
☒	Incomplete/Unclear Instructions
☐	Drill Holes
☒	Fit/Function

	Power Loss/Surge
	Folio/Program
	Grain Direction
	Weld
	Wrong Stock Pulled
	Out of Sequence
	Off-set/Set-up

	Positioned Wrong
	Outside Tolerance
	Drawing
	Finish
	Part Lost/Missing
	Misread